

Work Order ID 67822

Thursday, March 31, 2011 12:39:33 PM



Page 1

Item ID:	D4035-047	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Lid Rib Assembly, Aft (Light)					
Start Date:	3/31/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	4/7/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-31	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4035	A

100	Weld per dwg A/R Aluminum rod Batch:	0.00	
Large Fab			
Large Fab			

4114703

11.04.06 (2x)

Memo

1- Cut D4035-7 as per dwg D4035

2- Drill hole using DT9620 and chamfer holes as per dwg D4035

3- remove identification marks and deburr

4- Weld bushing in rib and grind weld flush as per dwg D4035

110	QC10- Inspect visual per QSI004- ground welds	0.00	
QC			
Quality Control			

Memo

8/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, March 31, 2011 12:39:33 PM

**Cust Item ID:**

Customer:

Reference:

Stop

1 2 3 4 5 6 7 8 9 10 11 12 13 14 15 16 17 18 19 20 21 22 23 24 25 26 27 28 29 30 31 32 33 34 35 36 37 38 39 40 41 42 43 44 45 46 47 48 49 50 51 52

**Insp.
Stamp**

8/104/02



QC

Memo

0.00

Quality Control

0.00



Packaging

Memo

0.00

Packaging

0.00



OC

Memo

0.00

Quality Control

11.04.12 (2)

11/4/14 DJ

N 11-074-13
(2)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, March 31, 2011 12:39:39 PM

Page 1

Work Order ID: 67822

Parent Item: D4035-047

Parent Item Name: Lid Rib Assembly, Aft (Light)

Start Date: 3/31/2011

Required Date: 4/7/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC
per dwg revA 10.03.15 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D4035-11 Bushing		Manufactured	No			100	Each	36.0000	2	4		11.04.06	
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Location	Loc Qty	Loc Code
ST109	4	
58376	4	
WA005	32	
59749	16	
63879	16	

✓ M6061T6TS0.750W.06 2 6061-T6 SQ Tube .75 x .75 x .062W		Purchased	No			100	f	134.0000	1.875	3.947368		11.04.06	
--	--	-----------	----	--	--	-----	---	----------	-------	----------	--	----------	--

Location	Loc Qty	Loc Code
MAT006	134	
194422	4	
116687	115	
9671	15	

3.947 + (1ft end bar scrap)

Dart Aerospace Ltd

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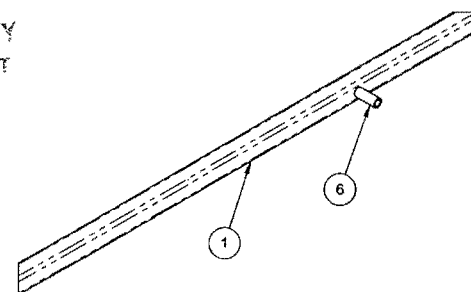
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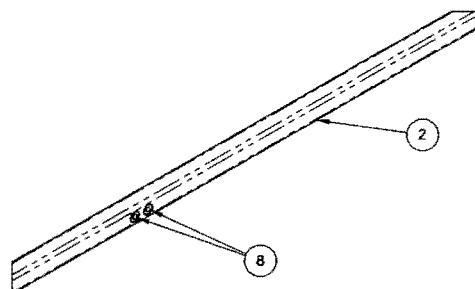
NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

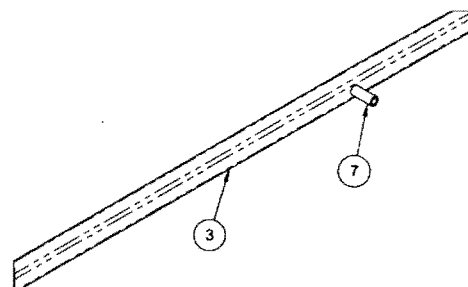
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67822
PL 11-03-31



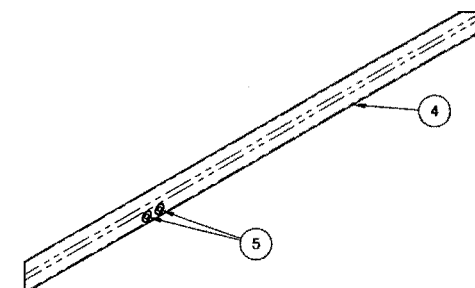
D4035-041 BASKET LID RIB ASSY, FWD



D4035-043 BASKET LID RIB ASSY, AFT



D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)



D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12
AW

A		NEW ISSUE		JPH	10.03.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4035 SHEET 1 OF 5 TITLE BASKET LID RIB ASSY SCALE NTS		REV. A	
DRAWN	JPH				
CHECKED					
MFG. APPR.					
APPROVED		DATE 10.03.04		<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS TO BE KEPT UNDER LOCK AND KEY. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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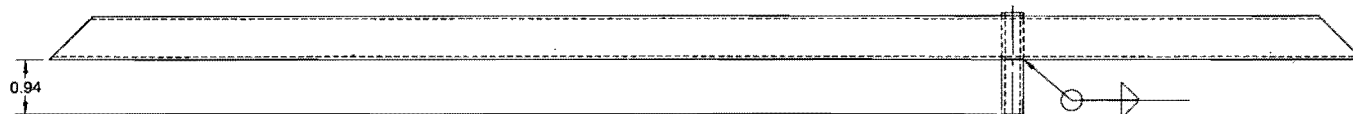
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8 7 6 5 4 3 2 1

D

D



D4035-1
RIB

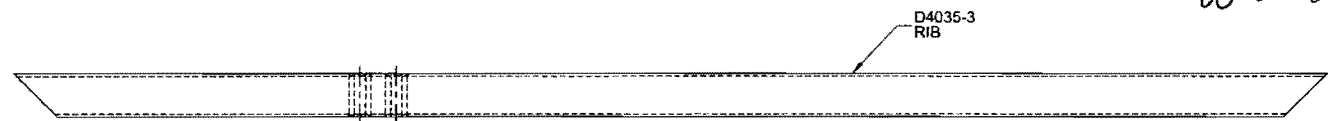
D2327-3
SPACER BUSHING

D4035-041 BASKET LID RIB ASSY, FWD

w/o 47822

C

C



D4035-3
RIB

D4021-9
BUSHING
2 PL

G
G
TYP

D4035-043 BASKET LID RIB ASSY, AFT

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

A

A

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8 7 6 5 4 3 2 1

D

D

D4035-5
RIB

D2953-175
SPACER

0.94

D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)

D4035-7
RIB

B

B

D4035-11
BUSHING
2 PL

G
G
TYP

D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)

RELEASED
2010-03-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

Wb 67822

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4035	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID RIB ASSY	NTS
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8 7 6 5 4 3 2 1

A

A

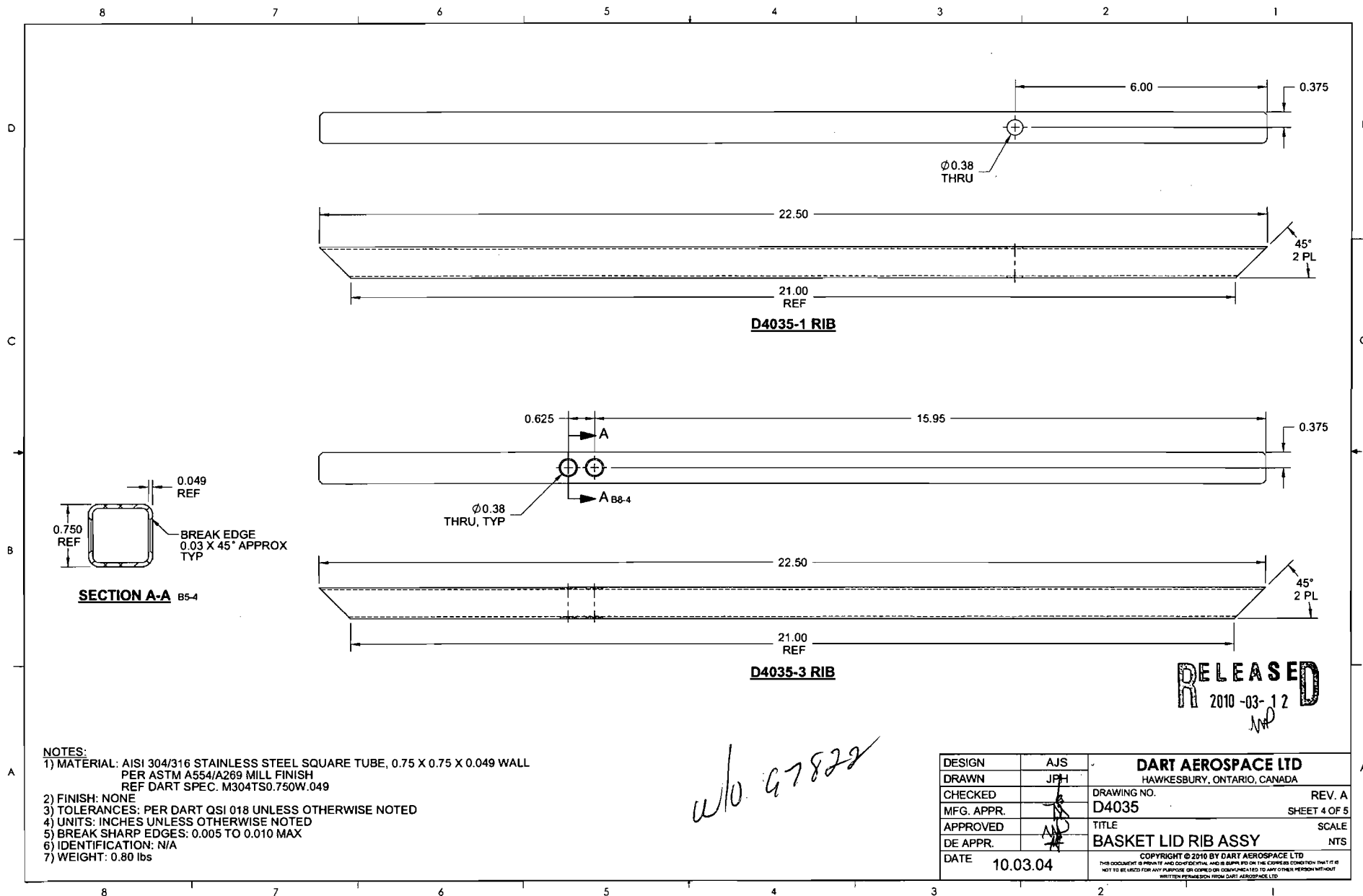
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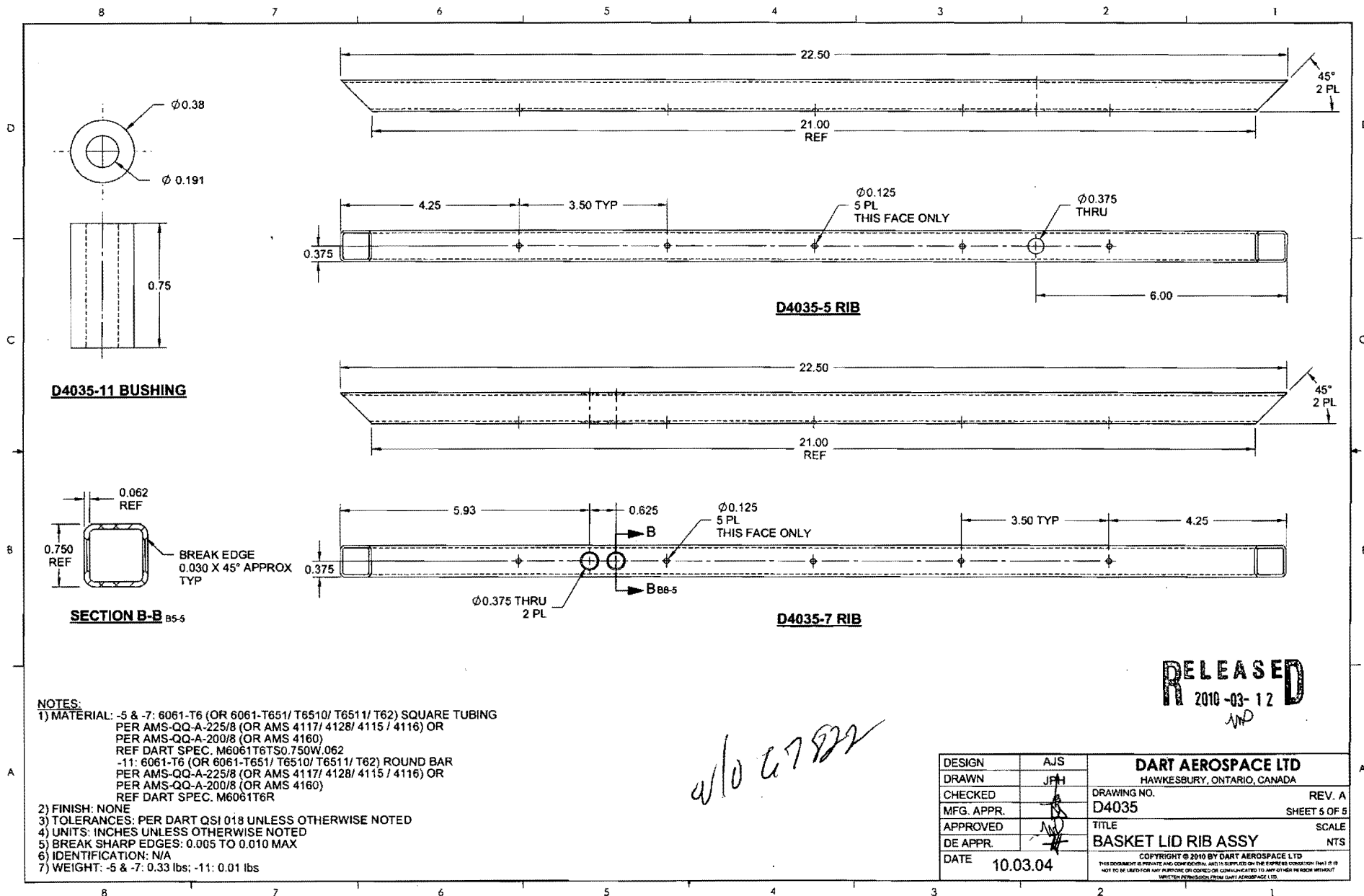
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